







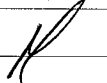


Work Order ID 69773

Thursday, May 19, 2011 8:53:58 AM


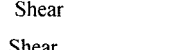

Page 1


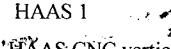

SHIP MAY 30




Item ID: D2274 Accept  Setup Start 
Revision ID:  Stop 
Item Name: Radius Block
Start Date: 5/19/2011 Start Qty: 100.00  Cust Item ID:
Required Date: 5/24/2011 Req'd Qty: 100.00  Customer:
Reference:

Approvals: Process Plan:  Date: 11-05-19 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2274	Rev F								

100  SHEAR 0.00
 Shear Memo 0.00 *ml 11/05/25* 100 
Shear blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 9 pieces

110  HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 1 Memo 0.00 *B.A 11/05/25* 100 
HAAS CNC vertical machine #1 Machine as per folio D2274

120  QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00 *B.A 11/05/25* 100 
Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69773

Thursday, May 19, 2011 8:53:58 AM



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Item ID: D2274

Accept



Setup Start



Revision ID:

Stop



Item Name: Radius Block

Start Date: 5/19/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				100	0		
140 Small Fab Small Fab	Small Fab Memo Tumble <input type="checkbox"/> Deburr any rough edges after tumbling	0.00 0.00				100	5-30		(100)
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				100	PR 11-5-30		

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NOTE: Date & initial all entries

Work Order ID 69773

Thursday, May 19, 2011 8:53:58 AM



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Item ID: D2274

Accept



Setup Start



Revision ID:

Stop



Item Name: Radius Block

Start Date: 5/19/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

100 X 0 M-L 4/05/30

170

Identify as per dwg & Stock Location: 10

0.00



Packaging

Memo

0.00

Packaging

11/5/30 SL 1000

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/31 J

CMF
11-05-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 69773

Parent Item: D2274

Parent Item Name: Radius Block



Start Date: 5/19/2011

Required Date: 5/24/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP H□00.05.18□Added inspection level 8□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	115.2000	0.0916	9.642105			



6061-T6 Bar .750 x .125



Location

Loc Qty

Loc Code

MAT001

115.2

116406

4.45

→ 116700

50.75

117653

60

~~254~~ 10.8 m 11/05/25

W/O:		WORK ORDER CHANGES						
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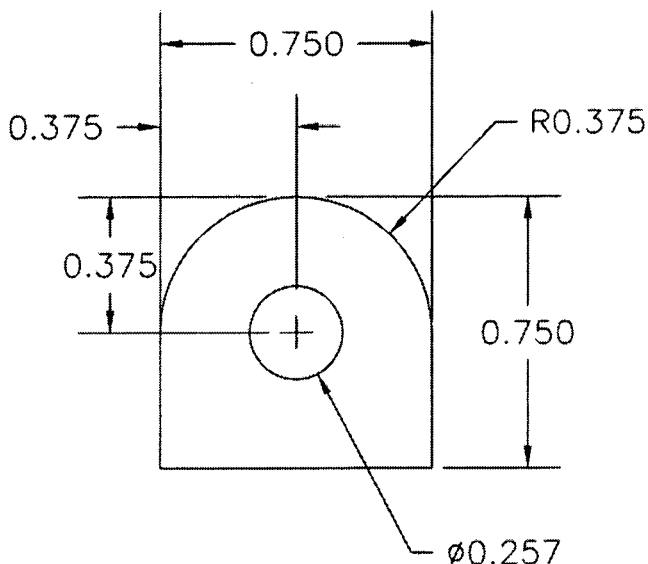
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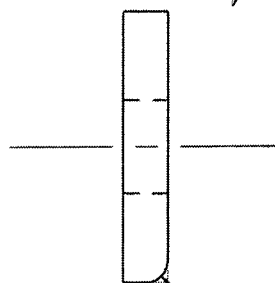


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *69773*
2011-05-15



00.05.16
00.05.16

0.063 x 45° CHAMFER
~~R0.0 - 0.13~~

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES						
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